

Date: Friday, 2/17/2006 10:29:53 AM
 User: Linda Lacelle

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : DOUBLER
Job Number : 25879	
Estimate Number : 10845	
P.O. Number : N/A	Part Number : D32833
This Issue : 2/17/2006 S.O. No. : N/A	Drawing Number : D3283 REV A
Prsht Rev. : NC	Project Number : N/A
First Issue : 2/17/2006 Type : MACHINED PARTS	Drawing Revision : A
Previous Run : 24885	Material : N/A
Written By : SEE COMMENT BELOW	Due Date : 2/24/2006
Checked & Approved By : <i>[Signature]</i>	Qty: 40 Um: Each
Comment : Est A 04.09.28 New issue KJ/JLM	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M6061T6S080	6061-T6 .080 Sheet
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Comment: Qty.: 0.3465 sf(s)/Unit Total : 13.8600 sf(s)
 6061-T6 .080 Sheet
 Material: 6061-T6 (QQ-A-250/11) 0.080" thick
 (M6061T6S.080)
 Identify for D3283-3

Batch: M19380

mk 06/02/18 40

2.0	SHEAR	SHEAR
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Comment: SHEAR
 Cut blanks: 15.550" x 2.450

mk 06/02/18 40

3.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
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Comment: HAAS CNC VERTICAL MACHINING #1
 Machine as per Folio FA424 and Dwg D3283
 Stack of 10
 Identify as D3283-3

mk 06/02/18 40

4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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**Comment:** INSPECT PARTS AS THEY COME OFF MACHINE

mk 06/02/18 40

5.0	QC8	SECOND CHECK
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**Comment:** SECOND CHECK

mk 06/02/18 40

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: DD Date: 06/02/18
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
06/02/18	3	12 pieces scrap the #40 drill broke inside the piece	<i>JB</i> <i>06/02/18</i>	destroy and replace	<i>ML</i> <i>06/02/18</i>	<i>[Signature]</i> <i>06-02-20</i>	<i>VB</i> <i>06-02-20</i>	<i>[Signature]</i> <i>06-02-20</i>

NOTE: Date & initial all entries

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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: DOUBLER

Job Number: 25879

Part Number: D32833

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: ST 419

C 206/02/20

(40)

7.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

Suc 06/02/21

(40)

22 06/02/21

Job Completion



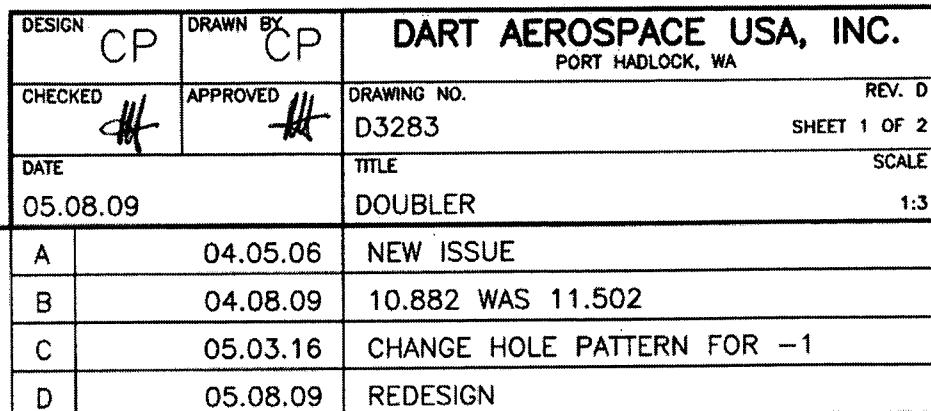
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

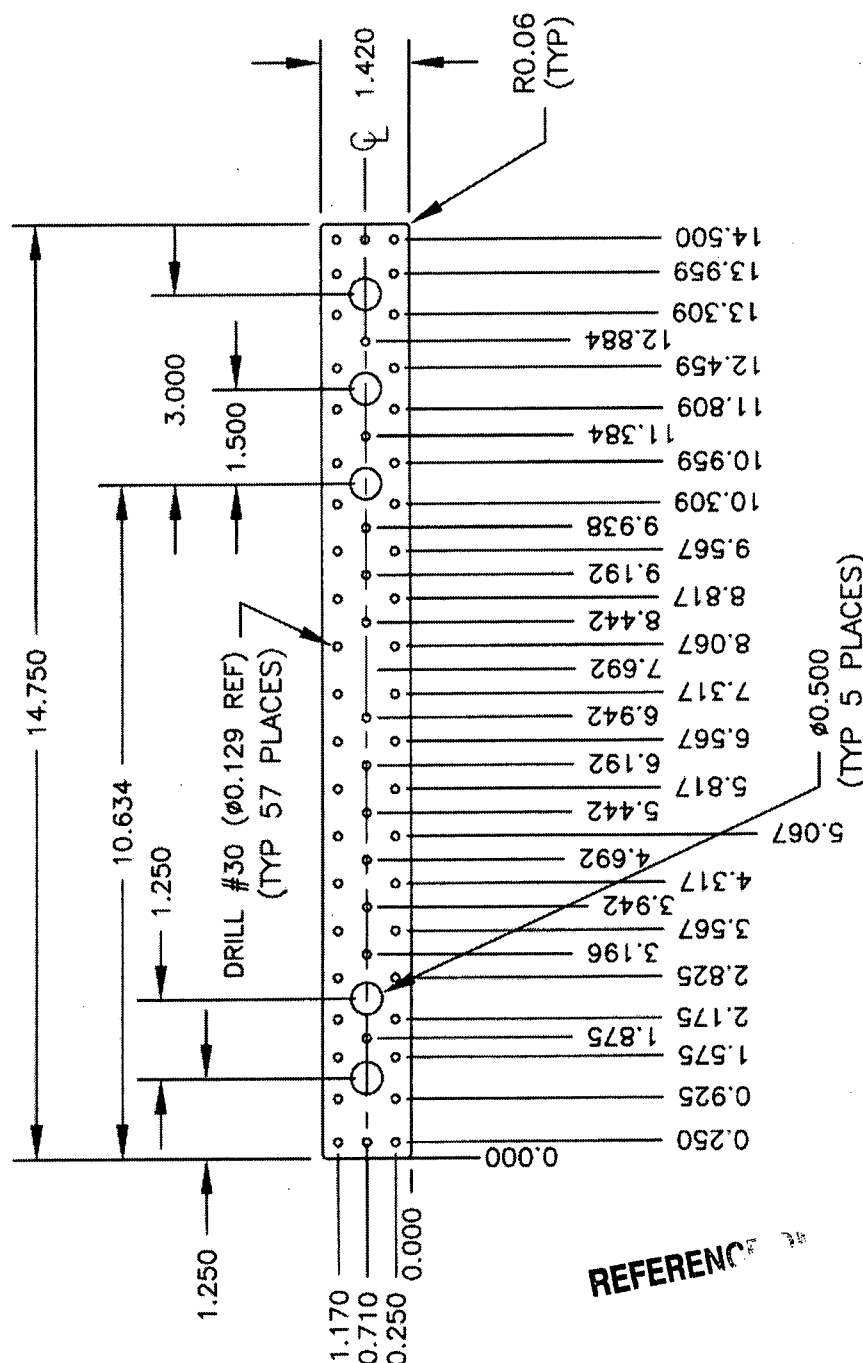
QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



RELEASED
05-09-06



D3283-1 DOUBLER

- 1) MATERIAL: 6061-T6, 0.063 THICK (QQ-A-250/11, REF DART SPEC. M6061T6S.063).
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES

REFERENCE

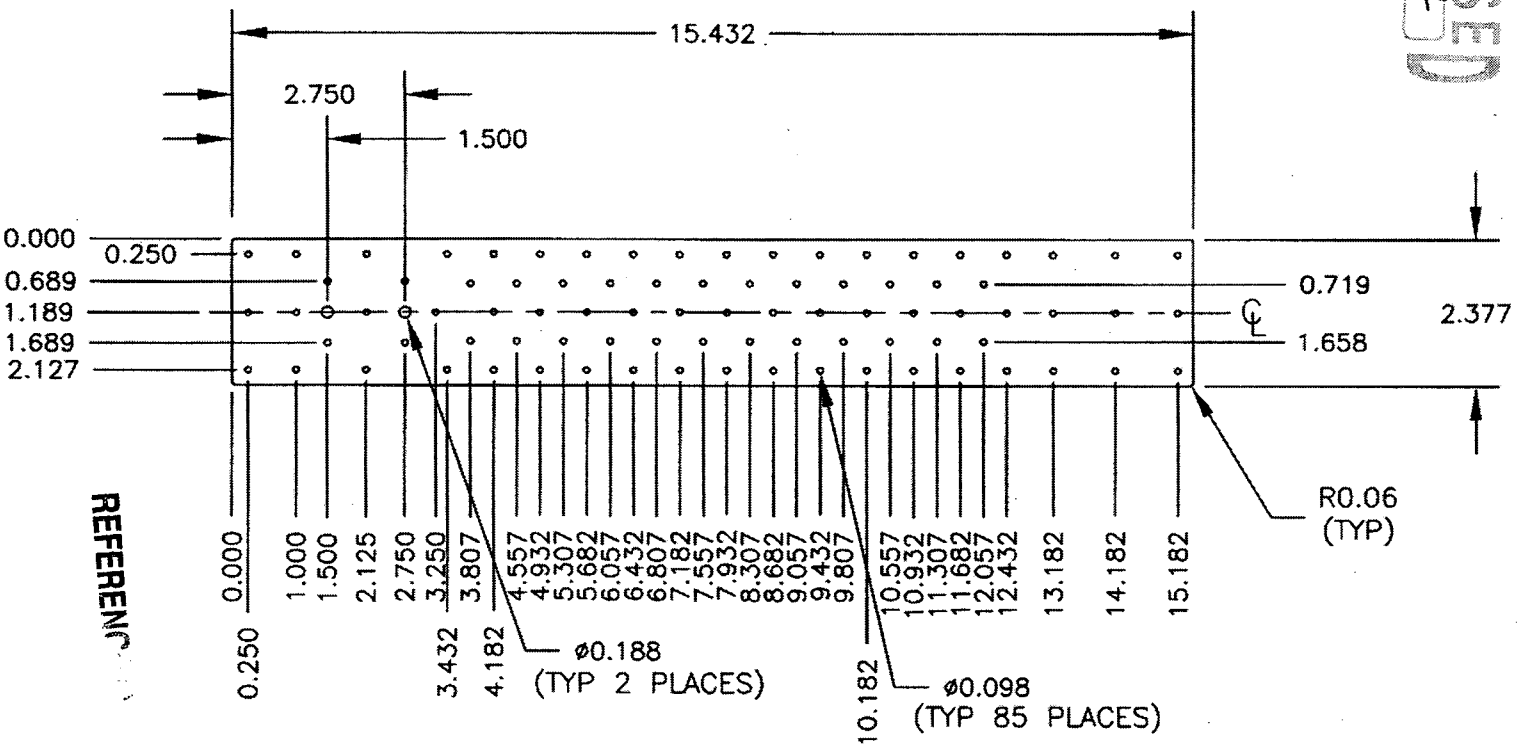
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DART

DESIGN	CP	DRAWN BY	CP	DART AEROSPACE USA, INC.
CHECKED	<i>[Signature]</i>	APPROVED	<i>[Signature]</i>	PORT HADLOCK, WA
DATE	05.08.09	TITLE	DOUBLER	REV. 0
		DRAWING NO.	D3283	SHEET 2 OF 2
		SCALE	1:3	

RELEASED
05-09-06



D3283-3 DOUBLER

- 1) MATERIAL: 6061-T6, 0.080 THICK (QQ-A-250/11, REF DART SPEC. M6061T6S.080)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES

